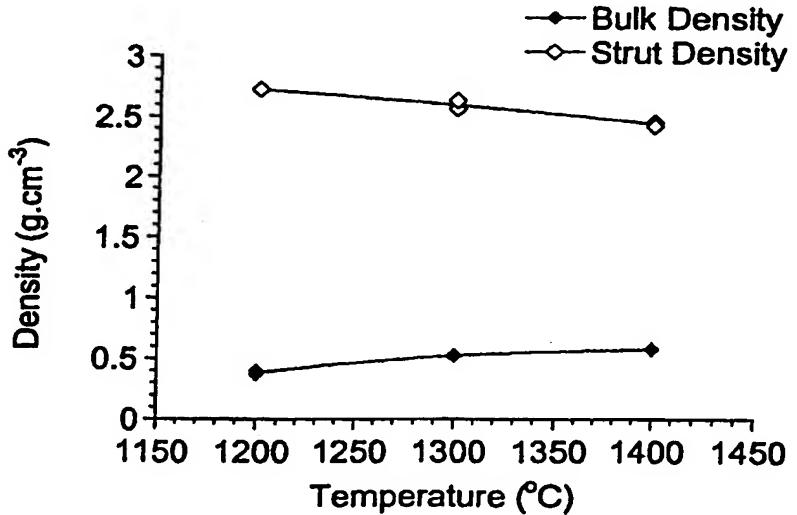




INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 7 : C04B 38/10, 38/02, C03C 11/00, A61L 27/10, 27/12		A1	(11) International Publication Number: WO 00/20353
			(43) International Publication Date: 13 April 2000 (13.04.00)
(21) International Application Number: PCT/GB99/03283		(81) Designated States: AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).	
(22) International Filing Date: 5 October 1999 (05.10.99)			
(30) Priority Data: 9821663.3 5 October 1998 (05.10.98) GB			
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(54) Title: FOAMED CERAMICS



(57) Abstract

The present invention relates to a method for the production of a macroporous ceramic foam, which method comprises: (a) forming a ceramic slip comprising a substantially homogeneous mixture of a ceramic particulate, an organic binder in a liquid carrier, and optionally one or more surfactants, wherein at least one surfactant is present if the organic binder does not function as a surfactant, and wherein the ceramic slip preferably has a viscosity in the range of from 15 to 200 mPas⁻¹; (b) foaming the ceramic slip; and (c) heating the foamed ceramic slip at a temperature sufficient to substantially burn out the organic binder. The macroporous ceramic foam is suitable for use in biomedical applications such as synthetic bones, tissue engineering scaffolds or drugdelivery devices.

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Foamed Ceramics

The present invention relates to a method for producing foamed ceramic materials and, in particular, 5 foamed ceramic materials which are suitable for use in biomedical applications.

The replacement of old, damaged or diseased bone is now an established procedure and an estimated 10 40,000 hip replacements are performed annually within Britain alone, of which 18% are revisions. As surgical technique and medical knowledge continue to advance, there is a growth in the demand for synthetic bone replacement materials, especially with health 15 concerns regarding homologous bone grafts, which are associated with the risks of viral infections, such as Hepatitis B and Human Immune deficiency Virus. Consequently, there is an increasing interest in the development of synthetic bone replacement materials 20 for the filling of both load bearing and non-load bearing osseous defects, such as in joint and facial reconstruction, with a resulting expansion in this field of research.

25 The biocompatibility of hydroxyapatite (HA), coupled with the similarities between the crystal structure of HA and the mineral content of bone, has led to great interest in HA as a material for the augmentation of osseous defects. The apatite group of 30 minerals are based on calcium phosphate, with stoichiometric hydroxyapatite having a molar ratio of Ca/P of 1.67. HA has the chemical formula $\text{Ca}_{10}(\text{PO}_4)_6(\text{OH})_2$. There has also been increasing interest in the development of biomaterials, such as

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bioactive glasses and substituted apatites, which more closely match the chemical composition of bone mineral, resulting in faster bone bonding between implant and host. However, as a result of the poor 5 mechanical properties of all of these materials, clinical usage has been limited to coatings and non-load bearing porous structures or granules.

Porous bio-ceramic implants offer the potential 10 of tailored-skeletal repair and reconstruction in a variety of orthopaedic procedures, as well as secure fixation of the implant as a result of bony ingrowth and mechanical interlock. There are a number of 15 porous HA based implant materials currently available on the commercial market, for example Unilab, Surgibone, Endobon (RTM), Ceros, Interpore. Many of these materials are derived from either animal cancellous bone or coral, which is hydrothermally treated so as to convert the natural ceramic component 20 into hydroxyapatite, while preserving the natural porous structure. For example, Endobon (RTM) is produced via the hydrothermal conversion of bovine cancellous bone. Others are formed by conventional burn-out routes, wherein polymer beads dispersed 25 throughout a ceramic structure are burnt out to leave a foam-like structure. This procedure generates significant gaseous by-products and often results in cracking of the structure.

30 There is limited information and control on the physical characteristics, such as the modal macro-pore size or the degree of pore inter-connectivity, in many of these porous structures, and in some cases there is limited control over the chemical composition. Both

the physical and chemical properties influence the quality and rate of bone ingrowth within these materials on implantation. Furthermore, the mechanical properties are highly sensitive to both 5 density- and anisotropy- parameters, which again are not well controlled in many of the current production routes. Therefore, there is a need for the development of a novel production route which allows control of the physical and chemical properties of the 10 final product. This results in improved implants in terms of mechanical and biological performance, as a function of tailored properties and improved reproducibility.

15 Ceramic foams are conventionally formed by infiltrating a polymer foam with a slip, which is a fine slurry of ceramic particles in a fluid, such as water. When the aggregate is fired, the slip bonds to the polymer foam to give an image of the original 20 foam, which is burnt off. Ceramic foams may also be made by chemical vapour deposition on to a substrate of reticulated carbon foam.

25 The present invention aims to provide a method for the manufacture of porous materials with highly interconnected porosity, which are suitable for use in medical applications.

30 Accordingly, the present invention provides a method for the production of a macroporous ceramic foam, which method comprises:

(a) forming a ceramic slip comprising a substantially homogeneous mixture of a ceramic particulate, an

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5 organic binder in a liquid carrier and optionally one or more surfactants, wherein at least one surfactant is present if the organic binder does not function as a surfactant, and wherein the ceramic slip preferably has a viscosity in the range of from 15 to 200 mPas⁻¹;

- (b) foaming the ceramic slip; and
- 10 (c) heating the foamed ceramic slip at a temperature sufficient to substantially burn out the organic binder.

For the avoidance of doubt, by the term
15 macroporous, as applied to an open foam structure, is
meant a ceramic foam containing pores with a modal
diameter $d_{\text{mode}} \geq \approx 100 \mu\text{m}$. By the term microporous, as
applied to the porosity within the struts of the
ceramic foam, is meant containing pores with a modal
20 diameter $0.1 \mu\text{m} \leq d_{\text{mode}} \leq 50 \mu\text{m}$.

Foams are three-dimensional cellular solids and may be classified as either open-celled or closed-cell. The relative density of a cellular material is defined as the ratio of the density of the cellular material to that of the solid material. For bone, the relative density generally falls within the range of from 0.05 to 0.7, i.e. 30 to 95 % porous. Furthermore, determination of the relative density of a porous structure can give an indication of the degree of pore connectivity with the structure. For cancellous bone, a structure with a relative density of less than approximately 0.2 (i.e. 80 % porous) is generally classed as open, while one with a relative density of

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more than approximately 0.2 (i.e. 80% porous) will possess a closed (non-interconnected) porosity.

The ceramic slip preferably has a viscosity in
5 the range of from 15 to 200 mPas⁻¹, more preferably
from 30 to 100 mPas⁻¹. It has been found that the
viscosity of the slip is important for producing a
stable foam, prior to burning out the binder. The
presence of a surfactant in the slip also assists in
10 producing a stable foam. It will be appreciated that
if the binder is capable itself of acting to a
sufficient extent as a surfactant, then the optional
surfactant(s) may be dispensed with. Suitable
examples of surfactants for use in the present
15 invention include Saponin and Decon 90.

The ceramic particulate may be a biocompatible
ceramic and may comprise, for example, one or more of
20 hydroxyapatite, a substituted-hydroxyapatite and/or
alumina, or any other ceramic used in biomedical
applications. The ceramic particulate may also
comprise a glass or a glass-ceramic such as, for
example, an AW-Glass ceramic. The ceramic particulate
25 may preferably be either a spray dried and/or calcined
powder, or, advantageously, it may be directly
obtained from the as-precipitated filter cake.

In general, the ceramic particulate has a
30 particle size distribution with the following
characteristics: d_{10} from 0.5 to 20, preferably from
0.5 to 5 μm , more preferably from 1 to 15 μm , still
more preferably from 0.7 to 2.5 μm , still more
preferably from 0.9 to 2.1 μm ; d_{50} from 1 to 300 μm ,
preferably from 2 to 150 μm , more preferably from 1 to

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15 μm , still more preferably from 1 to 10 μm , still more preferably from 3 to 8 μm ; and a d_{90} of from 5 to 150 μm , preferably from 5 to 50 μm , more preferably from 10 to 50 μm , still more preferably from 10 to 40 5 μm , still more preferably from 10 to 25 μm . The mode of the particle size will typically fall in the range of from 1 to 400 μm , preferably from 2 to 250 μm , more preferably from 1 to 10 μm , still more preferably from 10 10 to 6 μm . The ceramic particulate typically has a surface area of from 5 to 200 m^2g^{-1} , preferably from 7 to 100 m^2g^{-1} , more preferably from 7 to 20 m^2g^{-1} , and still more preferably from 7 to 14 m^2g^{-1} . Particle sizes were measured using a Malvern Mastersizer. 15 Surface areas were measured using a Micromeretics B.E.T. Surface Analyser.

The organic binder serves to provide plasticity during forming of the ceramic particulate and green strength in the formed product. In the present 20 invention, the organic binder preferably comprises an organic binder, which is preferably water soluble. Suitable examples include vinyl polymers, such as poly(vinyl alcohol), poly(vinyl pyrrolidone), poly(vinyl acetate) and/or poly(vinyl butyral). Other 25 suitable examples include alginate, poly(lactic acid) and poly(ethylene glycol). It will, however, be appreciated that any polymeric species capable of providing mechanical stability to a pre-sintered ceramic foam body may be used. It will also be 30 appreciated that the organic binders may be used singularly or in a combination of two or more thereof.

The liquid carrier should be one which can substantially dissolve the organic binder and which

can also be combined with the ceramic powder without causing degradation thereof. Suitable examples include water, preferably double distilled water, alcohols, such as propan-2-ol, and hydrocarbons, such as trichloroethane. The organic binder will generally be present in the liquid carrier in an amount of from 5 0.2 to 10 w/v%, preferably from 0.2 to 8 w/v%, more preferably from 0.5 to 6 w/v%, still more preferably from 0.5 to 4 w/v%, still more preferably from 1.5 to 10 3 w/v%.

The ceramic slip preferably comprises in the range of from 10 to 95 w/v% ceramic particulate in the binder and liquid carrier, more preferably from 20 to 15 90 w/v% ceramic particulate in the binder and liquid carrier, still more preferably from 40 to 80 w/v% ceramic particulate in the binder and liquid carrier. The slip may suitably be prepared by combining the constituents into a homogenous mixture. The 20 concentration of the binder solution added should preferably be selected to ensure that the percentage of binder remaining in a dry casting is in the range of from 0.5 to 10 w/w%, preferably from 1 to 6 w/w%, more preferably from 1 to 4 w/w%. The final slip 25 should preferably have a viscosity in the range of from 15 to 200 mPas⁻¹, more preferably from 30 to 100 mPas⁻¹, and this may be achieved by adjusting the slip viscosity by the addition of extra solvent, as necessary.

30

The ceramic slip may further comprise one or both of a dispersant and/or a defloculant. Suitable examples include sodium polyacrylate and/or sodium hexameta phosphate.

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Foaming of the ceramic slip may be achieved by one or more of mechanical agitation, gassing and/or the use of a blowing agent, such as H_2O_2 . For example, foaming may be achieved by the use of a 5 mechanical whisk and/or passing a gaseous phase through the slip until a substantially stable homogenous foam has been produced. Advantageously, foaming is achieved by the use of a ball mill (mill-foaming). Suitable milling media includes alumina 10 (Al_2O_3), enstatite ($MgSiO_3$) or zirconia (ZrO_2) balls, preferably having a diameter in the range of from 10 to 30 mm, more preferably from 15 to 25 mm. For biomedical applications, the milling media should be chosen carefully so as to avoid contamination of the 15 slip. The ball mill may be used in conjunction with gassing and/or a blowing agent. The amount of milling media to be used when mill-foaming a ceramic slip is advantageously in the range of from 3 to 20 w/w% ceramic particulate to milling media, more preferably 20 from 5 to 15 w/w%.

There are a number of advantages associated with ball milling foam-stabilised slips, including:-

25 (i) No organic sponge/foam template or solid pore-formers to burnout; porous ceramics produced by burnout methods often have relatively low mechanical properties resulting from defects in the structure due to incomplete/irregular burnout of the original 30 template.

(ii) Homogeneous or functionally graduated pore distributions are attainable by varying the slip viscosity.

(iii) Macro-pore size is variable by varying the start-powder particle size.

(iv) Macro-porosity is highly interconnected.

5

(v) Microstructure contains an interconnected network of micro-pores, the degree of connectivity of which can be controlled during sintering. This is important for tailoring the drug delivery characteristics of the porous structure.

Prior to burn-out of the organic binder, the liquid carrier is preferably allowed to evaporate from the foamed ceramic slip. This is beneficial because excessive quantities of the liquid carrier can lead to cracking during the subsequent heat-treatment steps. Evaporation may be facilitated by heating the foamed ceramic slip to a temperature in the range of from 20 to 100°C, preferably 30 to 50°C, and preferably with a flow of air thereover. As already mentioned, the concentration of the organic binder in the liquid carrier is advantageously selected so that the percentage of binder remaining after substantially all of the liquid carrier has been evaporated is in the range of from 0.5 to 10 w/w%, preferably from 1 to 6 w/w%, more preferably from 1 to 4 w/w%, since this has been found to reduce the occurrence of cracking during the subsequent heat-treatment steps. The viscosity of the slip and the presence of a surfactant/stabilizer assist in maintaining the foam structure of the ceramic slip during evaporation of the liquid carrier. In other words, the collapse of the form structure is delayed.

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The foamed ceramic slip will generally be cast in a mould prior to burn-out of the organic binder. The mould preferably has a surface coated with a release agent to ensure release of the casting(s) after 5 removal of the liquid carrier has occurred. The foamed ceramic slip may also be cast (unconstrained) on a flat surface, preferably dusted with a fine ceramic powder. Injection of the foamed ceramic slip into a porous mould is also possible.

10

It will be appreciated that the burn-out temperature will depend upon the nature of the organic binder. Generally the burn-out temperature will fall in the range of from 150 to 700°C, preferably 300 to 15 700°C, more preferably 300 to 600°C. Burn-out should preferably be carried out slowly in order to avoid creation of pressures due to decomposition of the organic binder and evaporation of any residual moisture. Sufficient amounts of oxygen or air should 20 preferably be supplied so that substantially complete binder burn-out can occur, and binder burn-out is therefore advantageously carried out in a ventilated furnace. Heating of the foamed ceramic slip is carried out at a rate and temperature sufficient to 25 substantially burn-out the organic binder.

Following burn-out of the organic binder, the ceramic foam may be sintered, again advantageously in a ventilated furnace. The sintering temperature 30 depends upon the nature of the ceramic particulate and will typically fall in the range of from 500 to 1600°C. It will be appreciated that the sintering temperature and atmosphere must be chosen carefully to avoid decomposition of the ceramic material. After

burn-out, humid, CO₂-rich atmospheres may be required for some ceramics, for example carbonate-substituted apatites. In particular, for carbonate-substituted apatite foams, specimens are preferably sintered at a 5 temperature in the range of from 600 to 1000°C under a carbon dioxide atmosphere, preferably in a tube furnace or the like, which is constantly flushed with CO₂ gas at a flow rate of typically up to 4 lmin⁻¹, preferably from 1 to 3 lmin⁻¹, more preferably 10 approximately 2.0 lmin⁻¹.

In a preferred embodiment of the present invention, following evaporation of the liquid carrier, the substantially dry green castings may 15 undergo a stepped heat-treatment for binder burn-out and densification by sintering. The optimum parameters for the burn-out step will depend on the binder being used. However, castings are typically heated at a rate of from 0.5 to 10°C min⁻¹ (preferably 20 from 1 to 5°C min⁻¹) and held at a burn-out temperature of from 150 to 700°C (preferably from 300 to 700°C) for from 2 to 8 hours. During the burn-out stage it is recommended that air is passed through the furnace 25 at a flow rate of preferably from 0.5 to 2 lmin⁻¹, more preferably from 1 to 2 lmin⁻¹, to ensure substantial removal of the binder. Once burn-out of the binder is complete, castings may be heated directly from the burn-out temperature, at a rate 30 typically from 1 to 20°Cmin⁻¹, to a sintering temperature appropriate for the ceramic powder, typically from 500 to 1600°C. Alternatively, castings that have undergone burn-out may be cooled to room temperature and then sintered. Upon sintering, it has been found that the struts of the material may

5 typically densify to from approximately 60 to \geq 95% (more typically from 70 to \geq 90%) of the theoretical density. On cooling, the sintered bodies are removed from the furnace and may be sectioned using a diamond tipped cutting apparatus into the desired geometry. The resulting solid foamed ceramic material may be provided in the form of, for example, blocks, cylinders and granules.

10 The foamed ceramic material produced by the method according to the present invention may be used as a synthetic bone material, including dental materials, for example for use in bone reconstruction and augmentation, implants, and compaction graft-type 15 fillers and for making hydroxyapatite-polymer composites.

20 The final macro-structure of the sintered ceramic foams produced according to the method of the present invention may be controlled by varying the relative proportions of the ingredients within the ceramic slip, the physical characteristics of the ceramic particulate and the amount of milling media added during mill-foaming, within the limits specified. 25 Hence, the bulk porosities of ceramic foams produced via this method typically range from 40 to 95 % (more typically from 60 to 90 %, still more typically from 60 to 80 %, still more typically from 70 to 80%). The macro-porosity of the sintered ceramic foams produced 30 according to the method of the present invention are highly interconnected (as can be seen in Figures 1 to 3). Furthermore, modal macro-pore size varies with bulk porosity, and ranges from 100 to 2000 μm , more typically from 100 to 1000 μm (as can be seen in

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Figures 7 and 8).

The final micro-structure of the sintered ceramic foams produced according to the method of the present invention may be controlled by varying the relative proportions of the ingredients within the ceramic slip, the physical characteristics of the ceramic particulate, the amount of milling media added during mill-foaming and, additionally by the sintering procedure, within the limits specified. The strut density (or real density) typically ranges from 60 to 95 % (more typically from 70 to 95%, still more typically from 85 to 92 %) of the theoretical density of the ceramic (the theoretical density of hydroxyapatite is 3.156 gcm^{-3}). However, the micro-porosity of the sintered ceramic foams produced according to the method of the present invention are highly interconnected (as can be seen in Figures 4 to 6 and 9 and 10) a characteristic of particular significance for bio-medical application.

Furthermore, the degree of interconnectivity within the microstructure of the sintered ceramic foams produced according to the method of the present invention, may be controlled by varying the relative proportions of the ingredients within the ceramic slip, the physical characteristics of the ceramic particulate, the amount of milling media added during mill-foaming and, additionally by the sintering procedure.

30

$$\text{Real (or Strut) Density} = \frac{\text{Mineralised Mass}}{\text{Volume of Bone Struts}}$$

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$$\text{Apparent (or Bulk) Density} = \frac{\text{Mineralised Mass}}{\text{Total (pore+strut) Volume}}$$

5 $\text{Bulk Porosity (\%)} = 100 \times (1 - \frac{\text{Apparent Density}}{\text{Theoretical Density}})$

10 $\text{Apparent Density} = \frac{\text{Dry Weight} \times \text{Density of Water}}{(\text{Saturated weight} - \text{Submerged weight})}$

15 $\text{Real Density} = \frac{\text{Dry Weight} \times \text{Density of Water}}{(\text{Dry weight} - \text{Submerged weight})}$

The present invention will now be described further with reference to the following Examples and Figures, provided by way of example, in which:

20 Figure 1 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to Example 1 of the present invention (sintering temperature 1200°C, magnification x50)

25 Figure 2 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to Example 1 of the present invention (sintering temperature 1300°C, magnification x50)

30 Figure 3 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to Example 1 of the present invention (sintering temperature 1400°C, magnification x1000)

35 Figure 4 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to

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Example 1 of the present invention (sintering temperature 1200°C, magnification x1000) (Ref: TAG 396).

5 Figure 5 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to Example 1 of the present invention (sintering temperature 1300°C, magnification x1000)

10 Figure 6 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to Example 1 of the present invention (sintering temperature 1400°C, magnification x50)

15 Figure 7 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to Example 4 of the present invention (55 w/v% particulate to carrier, magnification x50)

20 Figure 8 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to Example 4 of the present invention (50 w/v% particulate to carrier, magnification x50)

25 Figure 9 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to Example 4 of the present invention (55 w/v% particulate to carrier, magnification x1000)

30 Figure 10 is a SEM micrograph of a sintered mill-foamed porous ceramic material according to Example 4 of the present invention (50 w/v% particulate to carrier, magnification x1000)

Figure 11 is a plot of bulk and strut densities of sintered mill-foamed porous ceramics prepared according to Example 1 of the present invention

5 Example 1

3.0 g of polyvinyl alcohol (molecular weight 115000) was dissolved in 170 ml of double distilled water at 40°C, under conditions of continuous 10 stirring. This binder solution was then combined with 100 g of hydroxyapatite powder with a particle d_{50} of 3.3 μm and a surface area of $13.4 \text{ m}^2\text{g}^{-1}$. The resulting slip was then placed in a 1 litre mill pot with 945 g of milling media (18 mm diameter alumina balls) and 15 milled at a speed of 120 rpm for 2 hours. The thus foamed slip was then cast on to a flat surface which had been dusted with a fine hydroxyapatite powder, equivalent to 0.1 g cm^{-2} mould area, to ensure release of the casting once dry. Castings were dried in air 20 at a temperature of 40°C for from 12 to 24 hours. The dried green castings underwent a stepped heat treatment in a ventilated furnace for binder burn-out and densification by sintering. Castings were heated at a rate of $2.5^\circ\text{C min}^{-1}$ to 500°C, and held at this 25 temperature for 4 hours. Upon burn-out the castings were then heated at a rate of $2.5^\circ\text{C min}^{-1}$ to temperatures of 1200, 1300 and 1400°C, with no air flow and held for 2 hours. Figures 1 to 6 are SEM 30 micrographs of the thus formed materials: Figure 1 (sintering temperature 1200°C, magnification x50), Figure 2 (sintering temperature 1300°C, magnification x50), Figure 3 (sintering temperature 1400°C, magnification x1000), Figure 4 (sintering temperature 1200°C, magnification x1000), Figure 5 (sintering

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temperature 1300°C, magnification x1000), Figure 6 (sintering temperature 1400°C, magnification x50). The physical characteristics of the sintered specimens are detailed in Figure 11. The theoretical density of 5 hydroxyapatite is 3.156 gcm⁻³.

The results demonstrate how variation of sintering temperature results in control of both the bulk and strut density. Bulk density increases 10 steadily as sintering temperatures increases from 1200 to 1400°C, which reflects shrinkage of the macro-porosity, with a concurrent decrease in the macro-porous connectivity. However, strut density decreases from 1200 to 1400°C as a result of a reduction in 15 micro-pore connectivity leading to an increase in closed micropores.

Example 2

20 Two slips were prepared as in Example 1. The slips were then each placed in a separate 1 litre mill pot with 630 and 945 g of milling media (18 mm diameter alumina balls) and milled as a speed of 120 rpm for 5 hours. The foamed slips were then cast on 25 to a flat surface which had been dusted with a fine hydroxyapatite powder, equivalent to 0.1 gcm⁻² mould area, to ensure release of the casting once dry. Castings were dried at a temperature of 40°C. The dried green castings underwent a stepped heat 30 treatment for binder burn-out and densification by sintering. Castings were heated at a rate of 2.5°Cmin⁻¹ to 500°C, and held at this temperature for 4 hours. Upon burn-out the castings were then heated at 2.5°Cmin⁻¹ to a temperature of 1300°C, and held for 2

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hours. The physical characteristics of the sintered specimens are detailed in Table 1.

Table 1

5

Weight of Milling Media (g)	Bulk Density (gcm ⁻³)	Strut Density (gcm ⁻³)
630	0.65	2.75
945	0.54	2.74

10

The results in Table 1 demonstrate how variation in the weight of the milling media can be used to control of the bulk density (macro-porosity) independently of the strut density. Sintered mill-foamed porous ceramic prepared with a greater loading of milling media have a more open macro-porous structure.

15

Example 3

20

3.0 g of polyvinyl alcohol (molecular weight 115000) was dissolved in 130 ml of double distilled water at 40°C, under conditions of continuous stirring. This binder solution was then combined with 100 g of hydroxyapatite powder with a particle d_{50} of 7.5 μm and a surface area of 7.61 m^2g^{-1} . The resulting slip was then placed in a 1 litre mill pot with 945 g of milling media (18 mm diameter alumina balls) and milled at a speed of 120 rpm for 5 hours. The foamed slip was then cast on to a flat surface which had been dusted with a fine hydroxyapatite powder, equivalent to 0.1 gcm^{-2} mould area, to ensure release of the casting once dry. Casting were dried at a temperature

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of 40°C. The dried green castings underwent a stepped heat treatment for binder burn-out and densification by sintering. Casting were heated at a rate of 2.5°C min⁻¹ to 500°C, and held at this temperature for 4 hours. Upon burn-out, the castings were then heated at 2.5°C min⁻¹ to a temperature of 1300°C and held at this temperature for 2 hours. The physical characteristics of the sintered specimens are detailed in Table 2.

10

Table 2

15

Bulk Density (gcm ⁻³)	Strut Density (gcm ⁻³)
0.35	2.42

20

25

The results in Table 1, compared with the results of the sintered mill-foamed porous ceramics prepared with 945 g milling media in Table 2, demonstrate how variation in the particle size of the ceramic particulate may be used to control the bulk density (macro-porosity) and the strut density (micro-porosity). The sintered mill-foamed porous ceramics prepared with the ceramic particulate possessing a larger particle size had a greater modal pore size of 800 µm as compared to 300 µm.

Example 4

30

2.0 g of polyvinyl alcohol (molecular weight 115000) was dissolved in 90 ml of double distilled water at 40°C, under conditions of continuous stirring. 2.0 g of polyvinyl alcohol (molecular weight 115000) was dissolved in 100 ml of double

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distilled water at 40°C, under conditions of continuous stirring. These binder solutions were then each combined with 50 g of powdered hydroxyapatite filter-cake with a particle d_{50} of 40 5 μm and a surface area of $78 \text{ m}^2\cdot\text{g}^{-1}$. The resulting slips were then each placed in a 1 litre mill pot with 450 g of milling media and milled at a speed of 120 rpm for 2 hours. The foamed slips were then cast on to a flat surface which had been dusted with 10 sufficient fine hydroxyapatite powder, equivalent to 0.1 g per cm^2 mould area, to ensure release of the casting once dry. Castings were dried at a temperature of 40°C. The dried green castings underwent a stepped heat treatment for binder burn-out 15 and densification by sintering. Castings were heated at a rate of $1.0 \text{ }^{\circ}\text{C}\cdot\text{min}^{-1}$ to 500°C, and held at temperature for 4 hours. Upon burnout the castings were then heated to a temperature of 1250 °C, and held at temperature for 2 hours. The physical 20 characteristics of the sintered specimens are illustrated in Figures 7 to 10 and are detailed in Table 3.

25

Table 3

30

	Liquid Carrier (ml)	Bulk Density ($\text{g}\cdot\text{cm}^{-3}$)	Strut Density ($\text{g}\cdot\text{cm}^{-3}$)
	90	0.84	2.77
	100	0.41	2.39

The results in Table 3 and Figures 7 to 10 demonstrate how variation in the ratio of ceramic particulate to binder solution results in variation in 35 both the bulk density (macro-porosity) and the strut

density (micro-porosity). The sintered mill-foamed porous ceramics prepared with the greater volume of liquid carrier have lower bulk and strut densities reflecting a more open, inter-connected pore structure 5 with larger macro-pores and a larger fraction of micro-porosity. Furthermore, the use of powdered filter-cake has resulted in a more organised network of inter-connected microporosity.

10 The macroporous ceramic foams according to the present invention have the following advantages over the prior art cancellous and coral derived materials. First, the synthetic source means that there is total control over the choice of phase composition and the 15 level of chemical purity. Second, the processing route enables substantially complete control of the pore structure so as to minimise batch variation. Third, substantially isotropic structures can be produced. Fourth, the processing route enables the 20 structural features (such as the pore size and connectivity) of both the macro-porosity and micro-porosity to be tailored to the specific application so that structural and mechanical properties may be matched to particular requirements.

CLAIMS:

1. A method for the production of a macroporous ceramic foam, which method comprises:

5

(a) forming a ceramic slip comprising a substantially homogeneous mixture of a ceramic particulate, an organic binder in a liquid carrier, and optionally one or more surfactants, wherein at least one surfactant is present if the organic binder does not function as a surfactant, and wherein the ceramic slip preferably has a viscosity in the range of from 15 to 200 mPas⁻¹;

10

15 (b) foaming the ceramic slip; and

(c) heating the foamed ceramic slip at a temperature sufficient to substantially burn out the organic binder.

20

2. A method as claimed in claim 1, wherein foaming of the ceramic slip is achieved by one or more of mechanical agitation, gassing and/or a blowing agent.

25

3. A method as claimed in claim 1 or claim 2, wherein foaming of the slip is achieved by the use of a ball mill.

30

4. A method as claimed in claim 1 or claim 2, wherein foaming of the slip is achieved by the use of a mechanical whisk and/or passing a gaseous phase through the slip until a substantially stable homogenous foam has been produced.

5. A method as claimed in any one of the preceding claims, wherein the ceramic slip has a viscosity in the range of from 30 to 100 mPas⁻¹.
- 5 6. A method as claimed in any one of the preceding claims, wherein the ceramic particulate is biocompatible.
- 10 7. A method as claimed in any one of the preceding claims, wherein the ceramic particulate comprises one or more of hydroxyapatite, a substituted-hydroxyapatite, a glass, an AW-Glass ceramic and/or alumina.
- 15 8. A method as claimed in any one of the preceding claims, wherein the ceramic particulate has a d₅₀ of from 1 to 300 µm, preferably from 1 to 15 µm.
- 20 9. A method as claimed in any one of the preceding claims, wherein the ceramic particulate has a surface area in the range of from 5 to 20 m²g⁻¹.
- 25 10. A method as claimed in any one of the preceding claims, wherein the organic binder comprises one or more of poly(vinyl alcohol), poly(vinyl pyrrolidone), alginate, poly(lactic acid), poly(vinyl butyral), poly(ethylene glycol) and/or poly(vinyl acetate).
- 30 11. A method as claimed in any one of the preceding claims, wherein the liquid carrier comprises water, propan-2-ol or trichloroethane.
12. A method as claimed in any one of the preceding claims, wherein the organic binder is present in the

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liquid carrier in an amount of from 0.2 to 10 w/v%.

13. A method as claimed in claim 12, wherein the
organic binder is present in the liquid carrier in an
5 amount of from 0.5 to 6 w/v%, preferably from 0.5 to 4
w/v%.

14. A method as claimed in any one of the preceding
claims, wherein the ceramic slip comprises from 10 to
10 95 w/v% ceramic particulate.

15. A method as claimed in claim 14, wherein the
ceramic slip comprises from 20 to 90 w/v% ceramic
particulate, preferably from 40 to 980 w/v% ceramic
15 particulate.

16. A method as claimed in any one of the preceding
claims, wherein the ceramic slip further comprises one
or both of a dispersant and/or a defloculant.
20

17. A method as claimed in any one of the preceding
claims, wherein prior to burn-out of the organic
binder the liquid carrier is allowed to evaporate from
the foamed ceramic slip.
25

18. A method as claimed in claim 17, wherein the
foamed ceramic slip is heated at a temperature in the
range of from 20 to 100°C to facilitate evaporation of
the liquid carrier prior to burn-out of the organic
30 binder.

19. A method as claimed in claim 17 or claim 18,
wherein the concentration of the organic binder in the
liquid carrier is selected such that the percentage of

binder remaining after substantially all of the liquid carrier has been evaporated is from 0.5 to 10 w/w%.

20. A method as claimed in claim 19, wherein the 5 concentration of the organic binder in the liquid carrier is selected such that the percentage of binder remaining after substantially all of the liquid carrier has been evaporated is in the range of from 1 to 6 w/w%, preferably from 1 to 4 w/w%.

10 21. A method as claimed in any one of the preceding claims, wherein the foamed ceramic slip is cast in a mould having a surface coated with a release agent.

15 22. A method as claimed in any one of the preceding claims, wherein burn-out of the organic binder is carried out at a temperature in the range of from 150 to 700°C.

20 23. A method as claimed in any one of the preceding claims, further comprising sintering the ceramic foam following burn-out of the organic binder.

25 24. A method as claimed in claim 23, wherein sintering is carried out at a temperature in the range of from 500 to 1600°C.

30 25. A method as claimed in claim 23 or claim 24, wherein the sintered ceramic foam has a bulk porosity in the range of from 40 to 95%, preferably from 70 to 90%.

26. A method as claimed in any one of claims 23 to 25, wherein the sintered ceramic foam has a strut

density in the range of from 60 to 95%, preferably from 70 to 90% of the theoretical density of the ceramic.

5 27. A method as claimed in any one of claims 23 to 26, wherein the sintered ceramic foam has a modal pore size in the range of from 100 to 2000 μm , preferably from 100 to 1000 μm .

10 28. A method for the production of a macroporous ceramic foam, which method comprises:

15 (a) forming a ceramic slip comprising a substantially homogeneous mixture of a ceramic particulate, an organic binder in a liquid carrier, wherein the organic binder comprises one or more of poly(vinyl alcohol), poly(vinyl pyrrolidone), poly(vinyl acetate), poly(vinyl butyral), alginate, poly(lactic acid) and/or poly(ethylene glycol), and wherein the ceramic slip preferably has a viscosity in the range of from 15 to 200 mPas^{-1} ;

20 (b) foaming the ceramic slip, preferably by ball-milling;

25 (c) heating the foamed ceramic slip at a temperature sufficient to substantially burn-out the organic binder; and

30 (d) optionally sintering the ceramic foam following burn-out of the organic binder.

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29. A macroporous ceramic foam obtainable by a method according to any one of the preceding claims.

5 30. A synthetic bone material which comprises a macroporous ceramic foam as claimed in claim 29.

10 31. A composition which comprises a macroporous ceramic foam as claimed in claim 29 or a synthetic bone material as claimed in claim 30 together with a pharmaceutically acceptable diluent or carrier.

15 32. A bone implant, filler, cement, tissue engineering scaffold, synthetic bone graft or drug-delivery device which comprises a macroporous ceramic foam as claimed in claim 29, a synthetic bone material as claimed in claim 30 or a composition as claimed in claim 31.

20 33. A macroporous ceramic foam as claimed in claim 29, a synthetic bone material as claimed in claim 30 or a composition as claimed in claim 31 for use in a method of treatment of the human or animal body by surgery or therapy.

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30

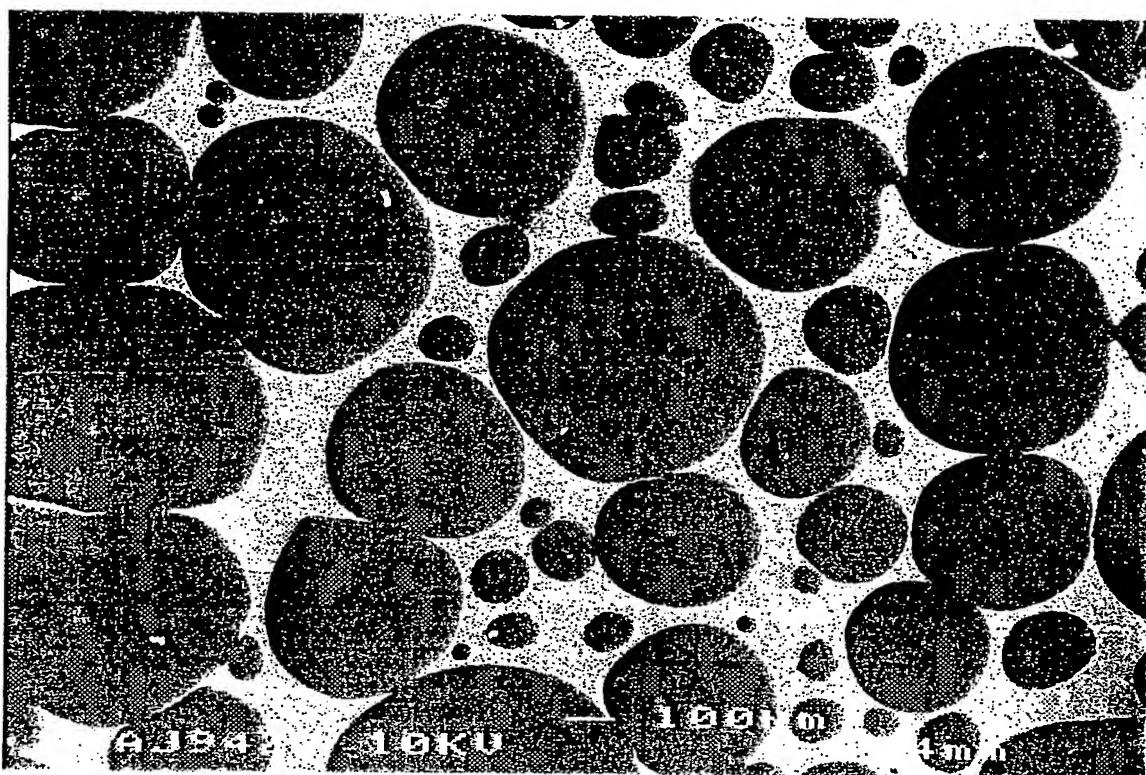


Figure 1 (Ref:TAJ942).

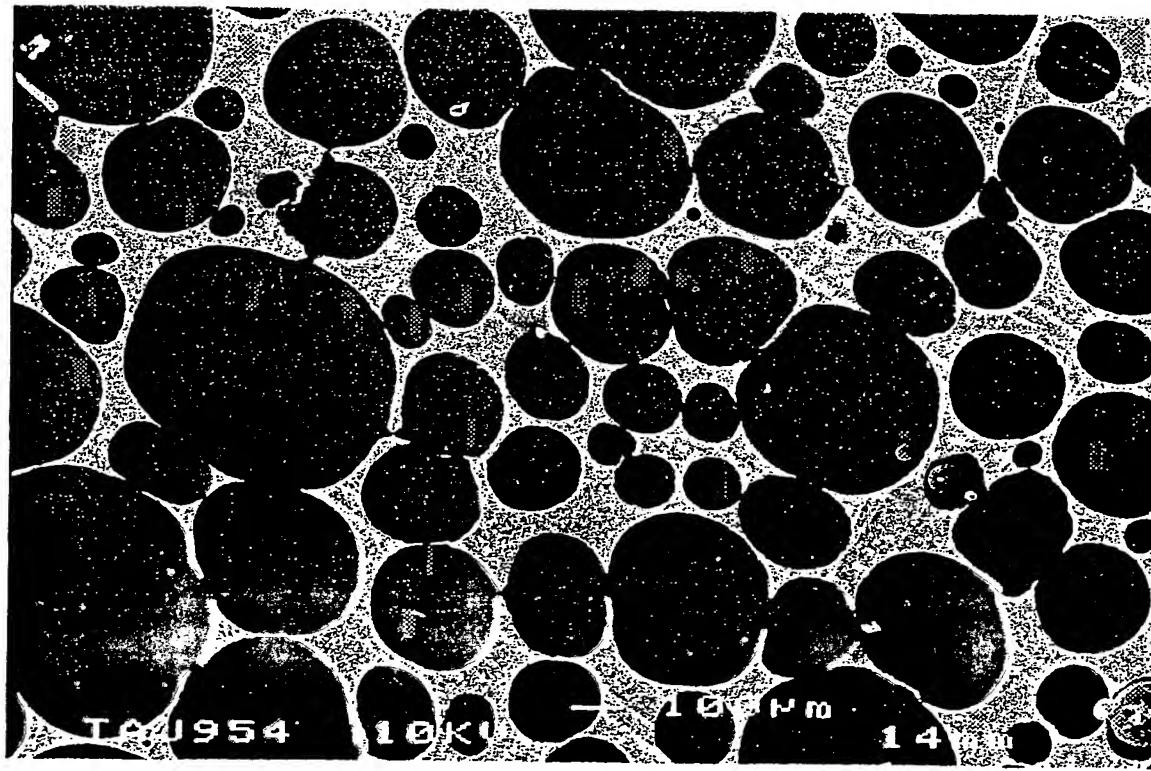


Figure 2 (Ref:TAJ954).

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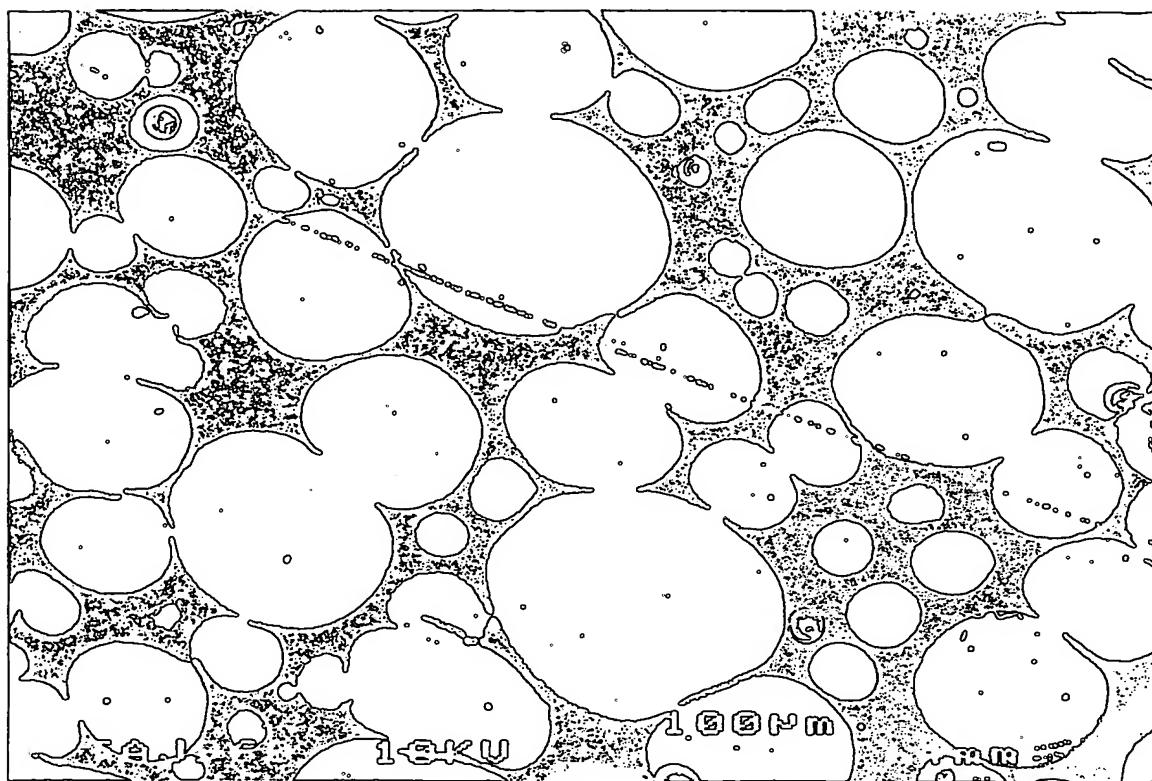


Figure 3 (Ref:TAJ960).

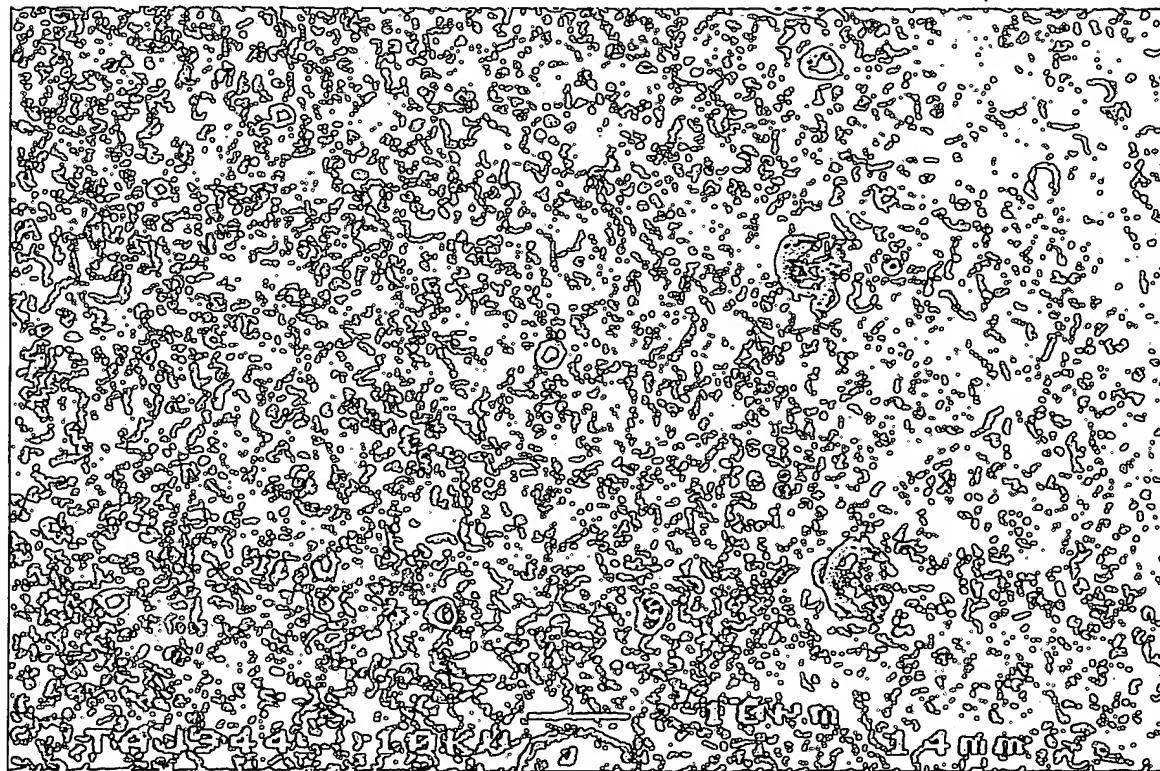


Figure 4 (Ref:TAJ944).

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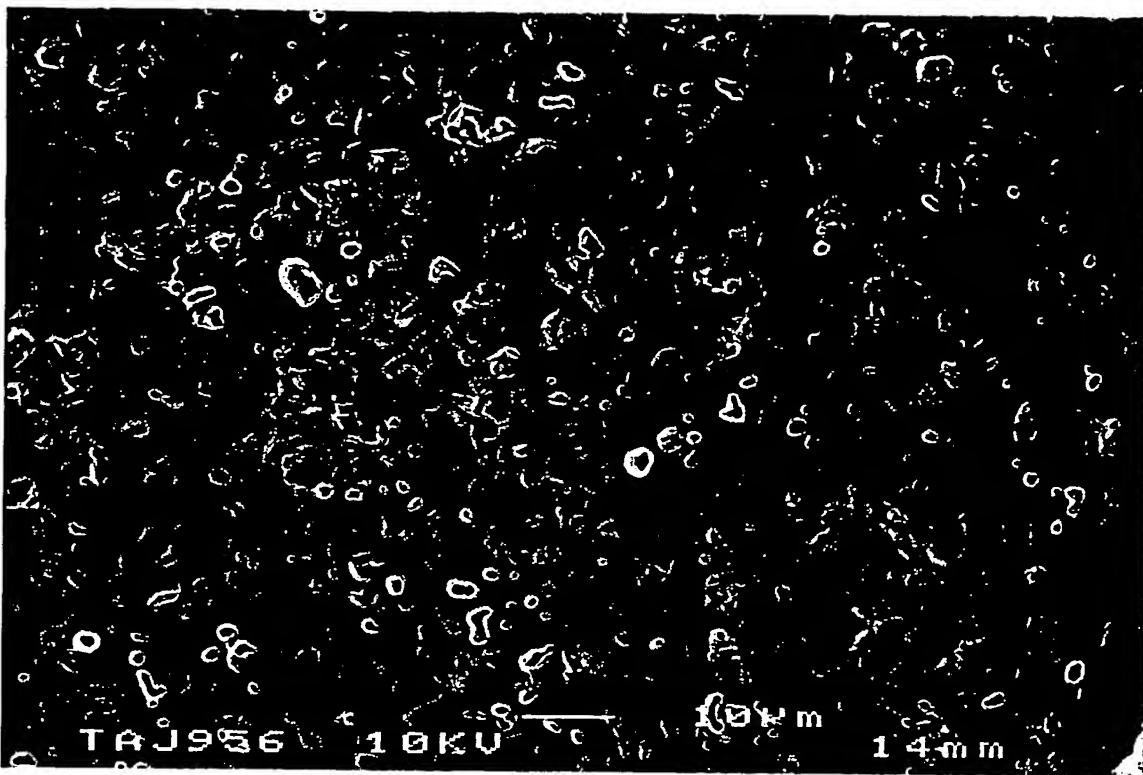


Figure 5 (Ref:TAJ956).

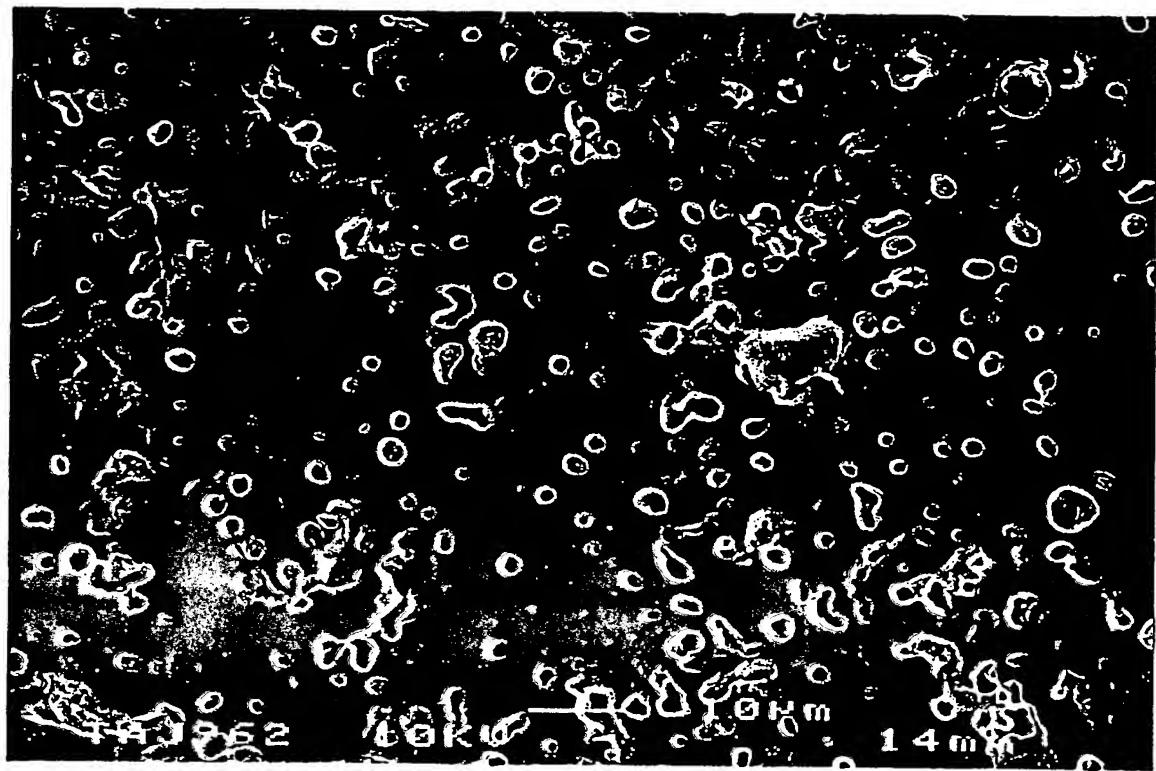


Figure 6 (Ref:TAJ962).

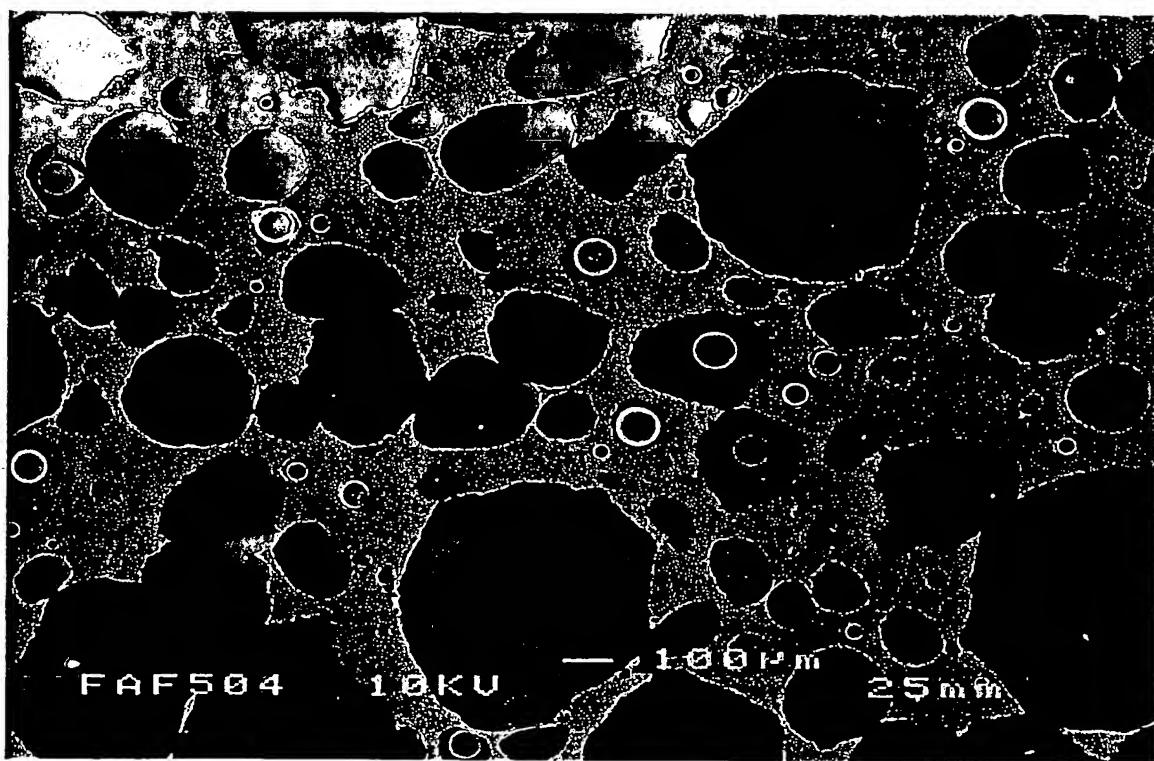


Figure 7 (Ref:FAF504).

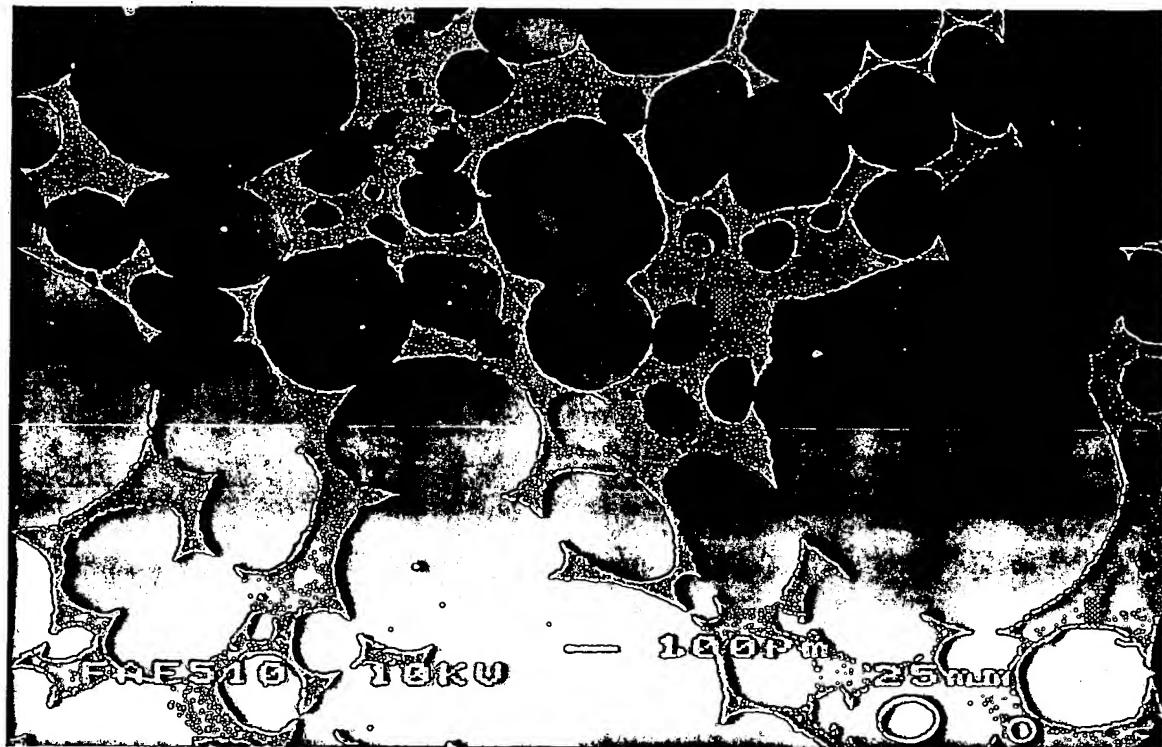


Figure 8 (Ref:FAF510).

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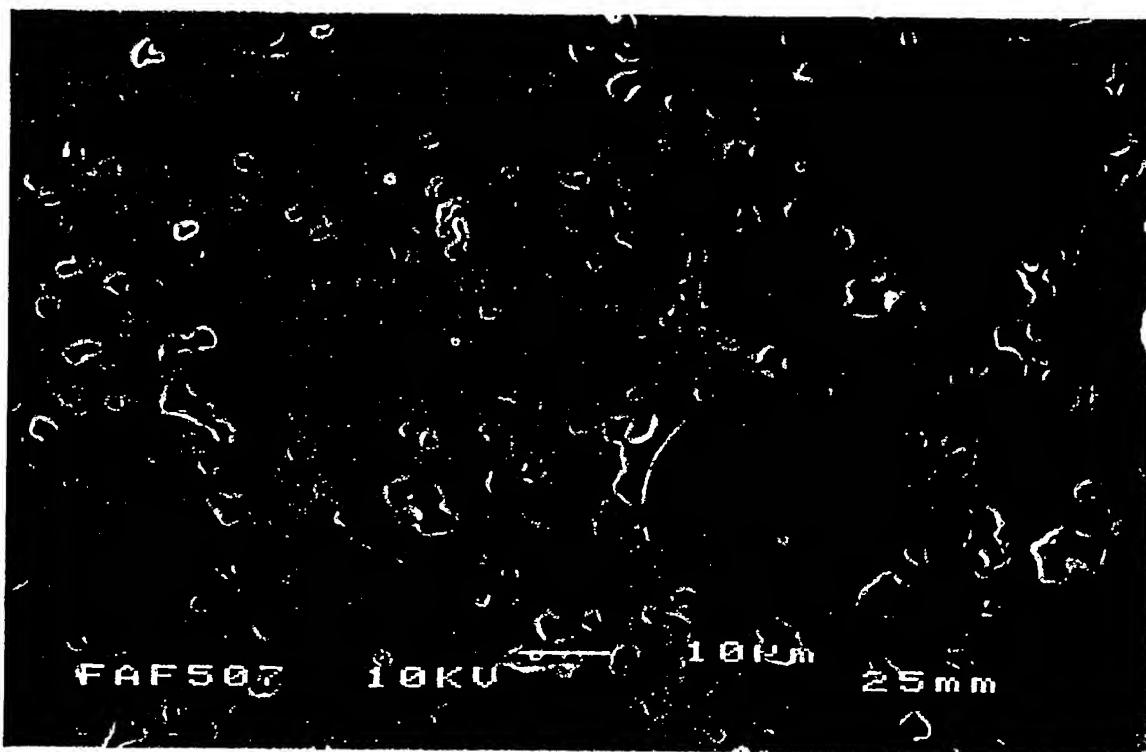


Figure 9 (Ref:FAF507).

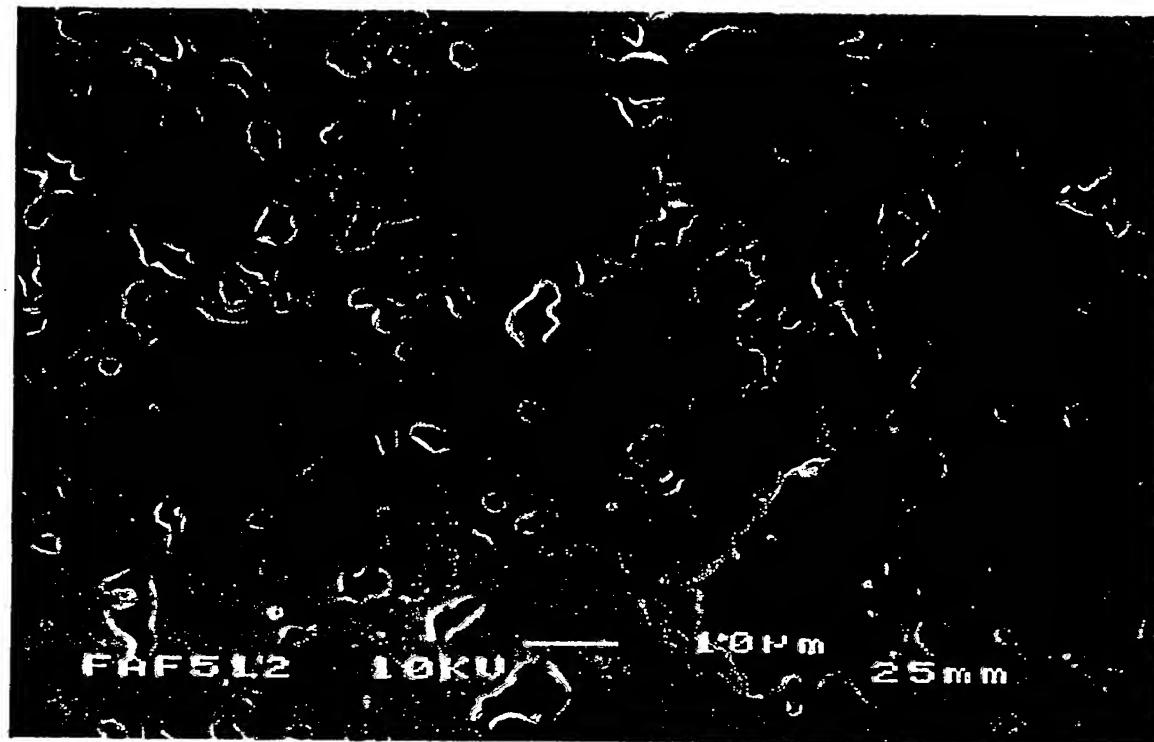


Figure 10 (Ref:FAF512).

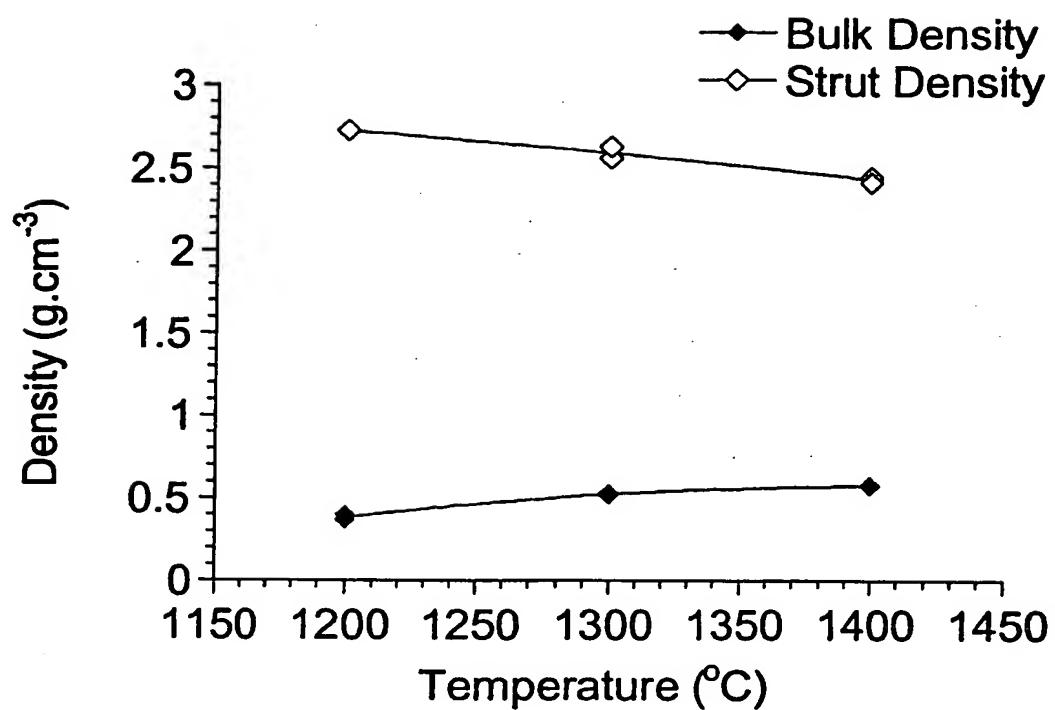


Figure 11

INTERNATIONAL SEARCH REPORT

Inte... onal Application No
PCT/GB 99/03283

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 C04B38/10 C04B38/02 C03C11/00 A61L27/10 A61L27/12

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 7 C04B A61L

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	<p>WO 93 04013 A (DYTECH CORP LTD) 4 March 1993 (1993-03-04)</p> <p>page 5, paragraph 1 page 7, paragraph 2; claims; examples V,VI ---</p>	1,3,5-8, 14, 16-18, 22-25, 28-33
A	<p>GB 2 317 887 A (DYTECH CORP LTD) 8 April 1998 (1998-04-08)</p> <p>page 4, last paragraph - paragraph 2 ---</p> <p style="text-align: center;">-/-</p>	1,2,4, 6-8,14, 16,17, 22-25, 29-33

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Patent family members are listed in annex.

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Date of the actual completion of the international search	Date of mailing of the international search report
11 January 2000	29/03/2000

Name and mailing address of the ISA	Authorized officer
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INTERNATIONAL SEARCH REPORT

International Application No

PCT/GB 99/03283

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0 851 402 A (ISHIKAWAJIMA HARIMA HEAVY IND) 1 July 1998 (1998-07-01) embodiment 1 page 6, line 24 - line 43 -----	1-3, 7, 10, 16, 17, 23-25, 27-29
A	US 5 266 248 A (HASHIMOTO SHINPEI ET AL) 30 November 1993 (1993-11-30) claims -----	1, 6, 7, 29-33

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/GB 99/03283

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GB 2317887	A 08-04-1998	AU 4563997	A	05-05-1998
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		US 5728395	A	17-03-1998

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